



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D205-634-041**  
**Job Sheet 201222**



**Part No:** D205-634-041

**Job Qty:** 1 pcs

**Part Name:** Replacement Skidtube with Standard Wearplates Fits LH or RH



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 9/27/19

**Job Tracking No:**

**Due Date:** 10/25/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation            | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|----------------------|----------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                      |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 110   | Skidtubes - Bend - 1 | 1<br>pcs |            | 10/25/19 | 0.00      | 0.65    | Skidtubes - Bend      |           | MGA      |
| 120   | Skidtubes - 2 - B4B  | 1<br>pcs |            | 10/25/19 | 0.00      | 2.89    | Skidtubes - 1 - B4B   |           |          |
|       |                      |          |            |          |           |         | Skidtubes - 2 - B4B   |           |          |
|       |                      |          |            |          |           |         | Skidtubes - 3 - B4B   |           | Mb-h     |
|       |                      |          |            |          |           |         | Skidtubes - 4 - B4B   |           |          |
|       |                      |          |            |          |           |         | Skidtubes - 5 - B4B   |           |          |
|       |                      |          |            |          |           |         | Skidtubes - 6 - B4B   |           |          |
|       |                      |          |            |          |           |         | Skidtubes - 7 - B4B   |           |          |
| 130   | QC 5                 | 1<br>pcs |            | 10/25/19 | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 12             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 17             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 18             |           | BE       |
|       |                      |          |            |          |           |         | QC 5 - 19             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 22             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 24             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 3              |           |          |
|       |                      |          |            |          |           |         | QC 5 - 43             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 49             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 51             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 58             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 68             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 9              |           |          |
|       |                      |          |            |          |           |         | QC 5 - 50             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 30             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 40             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 61             |           |          |
|       |                      |          |            |          |           |         | QC 5 - 81             |           |          |



**Container No:** S227906



**Part:** D205-634-041

**Job No:** 201222

**Serial No/Batch:** S227906

**Revision:** H

**Inspector:**

**Exp Date:**

**Instructions:** TC STC SH96-88 Issue 3, FAA STC SR005631

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

|                                   |          |          |           |                           |               |
|-----------------------------------|----------|----------|-----------|---------------------------|---------------|
| 140 Skidtubes - 3 - B4B           | 1<br>pcs | 10/25/19 | 0.00 3.00 | Skidtubes - 1 - B4B       |               |
|                                   |          |          |           | Skidtubes - 2 - B4B       |               |
|                                   |          |          |           | Skidtubes - 3 - B4B       | MLG           |
|                                   |          |          |           | Skidtubes - 4 - B4B       |               |
|                                   |          |          |           | Skidtubes - 5 - B4B       | BE            |
|                                   |          |          |           | Skidtubes - 6 - B4B       |               |
|                                   |          |          |           | Skidtubes - 7 - B4B       |               |
| 150 QC 10                         | 1<br>pcs | 10/25/19 | 0.00 0.00 | QC 10 - 10                |               |
|                                   |          |          |           | QC 10 - 18                |               |
|                                   |          |          |           | QC 10 - 24                |               |
|                                   |          |          |           | QC 10 - 43                |               |
|                                   |          |          |           | QC 10 - 50                |               |
|                                   |          |          |           | QC 10 - 58                |               |
|                                   |          |          |           | QC 10 - 9                 |               |
|                                   |          |          |           | QC 5 - 10                 |               |
| 160 QC 5                          | 1<br>pcs | 10/25/19 | 0.00 0.00 | QC 5 - 12                 |               |
|                                   |          |          |           | QC 5 - 17                 |               |
|                                   |          |          |           | QC 5 - 18                 |               |
|                                   |          |          |           | QC 5 - 19                 |               |
|                                   |          |          |           | QC 5 - 22                 |               |
|                                   |          |          |           | QC 5 - 24                 |               |
|                                   |          |          |           | QC 5 - 3                  |               |
|                                   |          |          |           | QC 5 - 43                 |               |
|                                   |          |          |           | QC 5 - 49                 |               |
|                                   |          |          |           | QC 5 - 51                 |               |
|                                   |          |          |           | QC 5 - 58                 |               |
|                                   |          |          |           | QC 5 - 68                 |               |
|                                   |          |          |           | QC 5 - 9                  |               |
|                                   |          |          |           | QC 5 - 50                 |               |
|                                   |          |          |           | QC 5 - 30                 |               |
|                                   |          |          |           | QC 5 - 40                 |               |
|                                   |          |          |           | QC 5 - 61                 |               |
|                                   |          |          |           | QC 5 - 81                 |               |
| 170 Handfinish - 1-1 Chemical-B4B | 1<br>pcs | 10/25/19 | 0.00 1.31 | Handfinish - 1 - 1 - B4B  | BE B19-11-12. |
|                                   |          |          |           | Handfinish - 1 - 2 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 3 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 4 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 5 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 6 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 7 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 8 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 9 - B4B  |               |
|                                   |          |          |           | Handfinish - 1 - 10 - B4B |               |
|                                   |          |          |           | Handfinish - 1 - 11 - B4B |               |
|                                   |          |          |           | Handfinish - 1 - 12 - B4B |               |
|                                   |          |          |           | Handfinish - 1 - 13 - B4B |               |
|                                   |          |          |           | Handfinish - 1 - 14 - B4B |               |
|                                   |          |          |           | Handfinish - 1 - 15 -     |               |

Plex 9/27/19 10:54 AM Dart.lajeunesse.marie

[https://www.plexonline.com/007afeb0-4278-466a-8fbb-90e73814d760/Plexus\\_Control/Report Viewer 2.asp?URL=../Part/Job Sheet.asp&Report=Tru...](https://www.plexonline.com/007afeb0-4278-466a-8fbb-90e73814d760/Plexus_Control/Report Viewer 2.asp?URL=../Part/Job Sheet.asp&Report=Tru...) 3/6

|                                 |          |          |      |      |                          |  |
|---------------------------------|----------|----------|------|------|--------------------------|--|
|                                 |          |          |      |      | Handfinish - 4 - 5 - B4B |  |
|                                 |          |          |      |      | Handfinish - 4 - 6 - B4B |  |
|                                 |          |          |      |      | Handfinish - 4 - 7 - B4B |  |
|                                 |          |          |      |      | Handfinish - 4 - 8 - B4B |  |
|                                 |          |          |      |      | Handfinish - 4 - 9 - B4B |  |
| 210 QC 5                        | 1<br>pcs | 10/25/19 | 0.00 | 0.00 | QC 5 - 10                |  |
|                                 |          |          |      |      | QC 5 - 12                |  |
|                                 |          |          |      |      | QC 5 - 17                |  |
|                                 |          |          |      |      | QC 5 - 18                |  |
|                                 |          |          |      |      | QC 5 - 19                |  |
|                                 |          |          |      |      | QC 5 - 22                |  |
|                                 |          |          |      |      | QC 5 - 24                |  |
|                                 |          |          |      |      | QC 5 - 3                 |  |
|                                 |          |          |      |      | QC 5 - 43                |  |
|                                 |          |          |      |      | QC 5 - 49                |  |
|                                 |          |          |      |      | QC 5 - 51                |  |
|                                 |          |          |      |      | QC 5 - 58                |  |
|                                 |          |          |      |      | QC 5 - 68                |  |
|                                 |          |          |      |      | QC 5 - 9                 |  |
|                                 |          |          |      |      | QC 5 - 50                |  |
|                                 |          |          |      |      | QC 5 - 30                |  |
|                                 |          |          |      |      | QC 5 - 40                |  |
|                                 |          |          |      |      | QC 5 - 61                |  |
|                                 |          |          |      |      | QC 5 - 81                |  |
| 220 Packaging 3-1 - Stock - B4B | 1<br>pcs | 10/25/19 | 0.00 | 0.00 | Packaging 3 - 1 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 2 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 3 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 4 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 5 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 6 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 7 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 8 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 9 - B4B    |  |
|                                 |          |          |      |      | Packaging 3 - 10 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 11 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 12 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 13 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 14 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 15 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 16 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 17 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 18 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 19 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 20 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 21 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 22 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 23 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 24 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 25 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 26 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 27 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 28 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 29 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 30 - B4B   |  |
|                                 |          |          |      |      | Packaging 3 - 31 - B4B   |  |

DAS  
NOV 20 2019 68  
9-89

|                  |     |          |           |                        |                    |
|------------------|-----|----------|-----------|------------------------|--------------------|
|                  |     |          |           | Packaging 3 - 32 - B4B |                    |
|                  |     |          |           | Packaging 3 - 33 - B4B |                    |
|                  |     |          |           | Packaging 3 - 34 - B4B |                    |
|                  |     |          |           | Packaging 3 - 35 - B4B |                    |
|                  |     |          |           | Packaging 3 - 36 - B4B |                    |
| 225 DC - 1 - B4B | 1   | 10/25/19 | 0.00 0.00 | DC - 1 - B4B           | DAS 21 NOV 21 2019 |
|                  | pcs |          |           | DC - 2 - B4B           | 21                 |
| 230 QC 21 - FG   | 1   | 10/25/19 | 0.00 0.00 | QC 21 - FG - 21        | DAS 21 NOV 21 2019 |
|                  | pcs |          |           | QC 21 - FG - 70        | 21                 |
|                  |     |          |           | QC 21 - FG - 53        | 21                 |

Part Op 110 - Skid tubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe Descriptions: batch# in aft end of tube

120 - Skid tubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skid tubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum START TIME: 8:15 OVEN TEMPERATURE: 320°

FINISH TIME: 8:45

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 200622 Sikaflex expire date: 20-7-22 Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291

Sikaflex expire date: 20-7-22 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5266627

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: PPP Rev:

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item   | Component Name          | Quantity       | Operation                         | Container |
|---------------|-------------------------|----------------|-----------------------------------|-----------|
| D2580-1       | 205 Bent Tube           | 1 pcs (1 ea)   | 110-Skid tubes - Bend - 1         | 5214193   |
| D2576-3       | Step (Machining Detail) | 1 pcs (1 ea)   | 140-Skid tubes - 3 - B4B          | 5177096   |
| D4202-1       | Spacer                  | 20 pcs (20 ea) | 140-Skid tubes - 3 - B4B          | 5184047   |
| ALS7-1032-130 | Rivnut                  | 50 Ea (50 ea)  | 200-Handfinish - 4-1-Assembly-B4B | 5209194   |
| AN3-5A        | Bolt                    | 2 Ea (2 ea)    | 200-Handfinish - 4-1-Assembly-B4B | 5216885   |
| AN3C4A        | Bolt                    | 50 Ea (50 ea)  | 200-Handfinish - 4-1-Assembly-B4B | 5228822   |
| D2594-1       | Plug                    | 16 pcs (16 ea) | 200-Handfinish - 4-1-Assembly-B4B | 5266811   |
| D2594-3       | O-Ring                  | 16 pcs (16 ea) | 200-Handfinish - 4-1-Assembly-B4B | 5045947   |
| D2855         | Cap                     | 1 pcs (1 ea)   | 200-Handfinish - 4-1-Assembly-B4B | 5194521   |
| D3564-11      | Wearplate Aft           | 1 pcs (1 ea)   | 200-Handfinish - 4-1-Assembly-B4B | 5201764   |
| D3564-13      | Wearpad Fwd             | 1 pcs (1 ea)   | 200-Handfinish - 4-1-Assembly-B4B | 5267800   |
| D3564-5       | Wearplate Center        | 1 pcs (1 ea)   | 200-Handfinish - 4-1-Assembly-B4B | 5268675   |
| D3564-9       | Wearplate Fwd           | 1 pcs (1 ea)   | 200-Handfinish - 4-1-Assembly-B4B | 5208809   |
| NAS1149C0332R | Washer (AN960C10L)      | 50 Ea (50 ea)  | 200-Handfinish - 4-1-Assembly-B4B | 5218151   |
| NAS1149D0332J | Washer                  | 2 Ea (2 ea)    | 200-Handfinish - 4-1-Assembly-B4B | 5178378   |

012912

| Job Allocations                   |                |          |           |           |
|-----------------------------------|----------------|----------|-----------|-----------|
| Operation                         | Component Part | Required | Inventory | Allocated |
| 110-Skidtubes - Bend - 1          | D2580-1        | 1        | 11        | 0         |
| 140-Skidtubes - 3 - B4B           | D2576-3        | 1        | 70        | 0         |
|                                   | D4202-1        | 20       | 700       | 0         |
| 200-Handfinish - 4-1-Assembly-B4B | ALS7-1032-130  | 50       | 1,502     | 0         |
|                                   | AN3-5A         | 2        | 272       | 0         |
|                                   | AN3C4A         | 50       | 484       | 0         |
|                                   | D2594-1        | 16       | 59        | 0         |
|                                   | D2594-3        | 16       | 466       | 0         |
|                                   | D2855          | 1        | 78        | 0         |
|                                   | D3564-11       | 1        | 9         | 0         |
|                                   | D3564-13       | 1        | 26        | 0         |
|                                   | D3564-5        | 1        | 19        | 0         |
|                                   | D3564-9        | 1        | 18        | 0         |
|                                   | NAS1149C0332R  | 50       | 2,501     | 0         |
|                                   | NAS1149D0332J  | 2        | 1,766     | 0         |

**Part Specifications**

Specifications could not be found.

Plex 9/27/19 10:54 AM Dart.lajeunesse.marie

| ITEM | QTY<br>-041 | QTY<br>-045 | QTY<br>-047 | QTY<br>-048 | PART NUMBER                                                               | DESCRIPTION        |
|------|-------------|-------------|-------------|-------------|---------------------------------------------------------------------------|--------------------|
| 1    | X           |             |             |             | D2580-041                                                                 | SKIDTUBE ASSEMBLY  |
| 2    |             | X           |             |             | D2580-048                                                                 | SKIDTUBE ASSEMBLY  |
| 3    |             |             | X           |             | D2580-047                                                                 | SKIDTUBE ASSEMBLY  |
| 4    |             |             |             | X           | D2580-046                                                                 | SKIDTUBE ASSEMBLY  |
| 20   | 1           | 1           | 1           | 1           | D2580-1-100                                                               | EXTRUSION          |
| 21   |             |             | 10          | 10          | D2570                                                                     | BUSHING            |
| 22   | 1           | 1           | 1           | 1           | D2573-3                                                                   | STEP               |
| 23   |             | 4           |             |             | D2570                                                                     | SPACER             |
| 24   | 16          | 16          | 8           | 8           | D2584-1                                                                   | PLUG               |
| 25   | 18          | 18          | 8           | 8           | D2584-3                                                                   | O-RING             |
| 26   | 1           | 1           | 1           | 1           | D2590                                                                     | 200 WEB            |
| 27   | 1           | 1           | 1           | 1           | D2585                                                                     | AFT CAP            |
| 28   | 1           | 1           |             |             | D2584-3                                                                   | WEARSHOE           |
| 29   | 1           | 1           |             |             | D2584-9                                                                   | WEARSHOE           |
| 30   | 1           | 1           |             |             | D2584-11                                                                  | WEARSHOE           |
| 31   | 1           | 1           |             |             | D2584-13                                                                  | WEARSHOE           |
| 32   | 20          | 20          | 24          | 24          | D4002-1                                                                   | SPACER             |
| 33   |             |             | 1           |             | D4002-041                                                                 | WEARPLATE ASSEMBLY |
| 34   |             |             | 1           |             | D4002-043                                                                 | WEARPLATE ASSEMBLY |
| 35   |             |             |             | 1           | D2581-1                                                                   | PWD WEARPLATE      |
| 36   |             |             |             | 1           | D2581-3                                                                   | AFT WEARPLATE      |
| 60   | 50          | 50          |             |             | AL57-1032-130<br>or AK57-1032-130<br>or AK59-1032-130<br>or AL59-1032-130 | INSERT             |
| 61   | 50          | 50          |             |             | AN50A                                                                     | BOLT               |
| 62   | 2           | 2           | 2           | 2           | AN50A                                                                     | BOLT               |
| 63   |             |             | 8           | 8           | AN4-45A                                                                   | BOLT               |
| 64   | 50          | 50          |             |             | NAS114RC032R                                                              | WASHER (AN800C10L) |
| 65   | 2           | 2           | 2           | 2           | NAS114RC032J                                                              | WASHER (AN800C10L) |
| 66   |             |             | 8           | 8           | MS1043-4                                                                  | NUT (OR MS21042L4) |

# GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QBI 005 4.1 PRIOR TO INSERTING D2580 WEB POWDER COAT (-041-047-048) GLOSS WHITE (REF 4.3.5.1) PER DART QBI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED PER DART QBI 005 4.4.
- 4) TOLERANCES ARE PER DART QBI 018 UNLESS OTHERWISE NOTED.
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK SHARP EDGES: 0.003 TO 0.010 MAX.
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D2580-041 = 33.7 lbs  
D2580-043 = 45.1 lbs  
D2580-046 = 52.0 lbs
- 9) WELDING PER DART QBI 004.
- 10) INSERT D2580 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QBI 018 BEFORE BONDING. ENSURE HOLES LINE-UP.
- 11) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 12) USE DART DRILL TEMPLATE DTR217 & DTR237 ONLY FOR D2580-041-045 TO LOCATE AND DRILL 60.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (60 PLACES) AFTER FINISH. INSTALL AN50A BOLTS AND NAS114RC032R WASHERS WITH SIKAFLEX-241-291.
- 13) INSERT D2584-1 PLUG CW D2584-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2580-041-046 AND 8 PLACES FOR D2580-047-048)
- 14) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2580 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

| REV.        | DESCRIPTION                                                                                                                                              | BY   | DATE     |
|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|------|----------|
| H           | SHEET: PL DELETE D2580-1-041-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS                               | SAD  | 17.06.09 |
| G           | ADDED -048 -047 WEIGHT UPDATED PER DSI 8008                                                                                                              | AJS  | 14.04.09 |
| F           | INCORPORATE DEO D2580-E-1 PER PART 2-318                                                                                                                 | DC   | 13.06.08 |
| E           | ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN BS-5); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR217 & DTR237 WAS D2587-265 (ZN C4-1) | RF   | 11.06.21 |
| D           | CHANGE TO S3 WEARPLATES AND GASKETS,                                                                                                                     | PH   | 07.04.06 |
| C           | INCLUDE DEO 9124/9183                                                                                                                                    | CP   | 06.02.06 |
| B           | REDRAWN, INCLUDED DEO 9004/0007                                                                                                                          | DS   | 06.12.02 |
| A           | AS MANUFACTURED                                                                                                                                          | DS   | 06.03.16 |
| A           | NEW ISSUE                                                                                                                                                | DS   | 06.03.16 |
| DESIGN      | DS                                                                                                                                                       | DATE |          |
| DRAWN       | SAD                                                                                                                                                      |      |          |
| CHECKED     | <i>[Signature]</i>                                                                                                                                       |      |          |
| INFO. APPR. | <i>[Signature]</i>                                                                                                                                       |      |          |
| APPROVED    | <i>[Signature]</i>                                                                                                                                       |      |          |
| DE APPR.    | <i>[Signature]</i>                                                                                                                                       |      |          |
| DATE        | 17.06.09                                                                                                                                                 |      |          |

RELEASED  
2017 JUL 05/1  
201222 MJS  
19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY

ORDER

201222 MJS

19-05-27

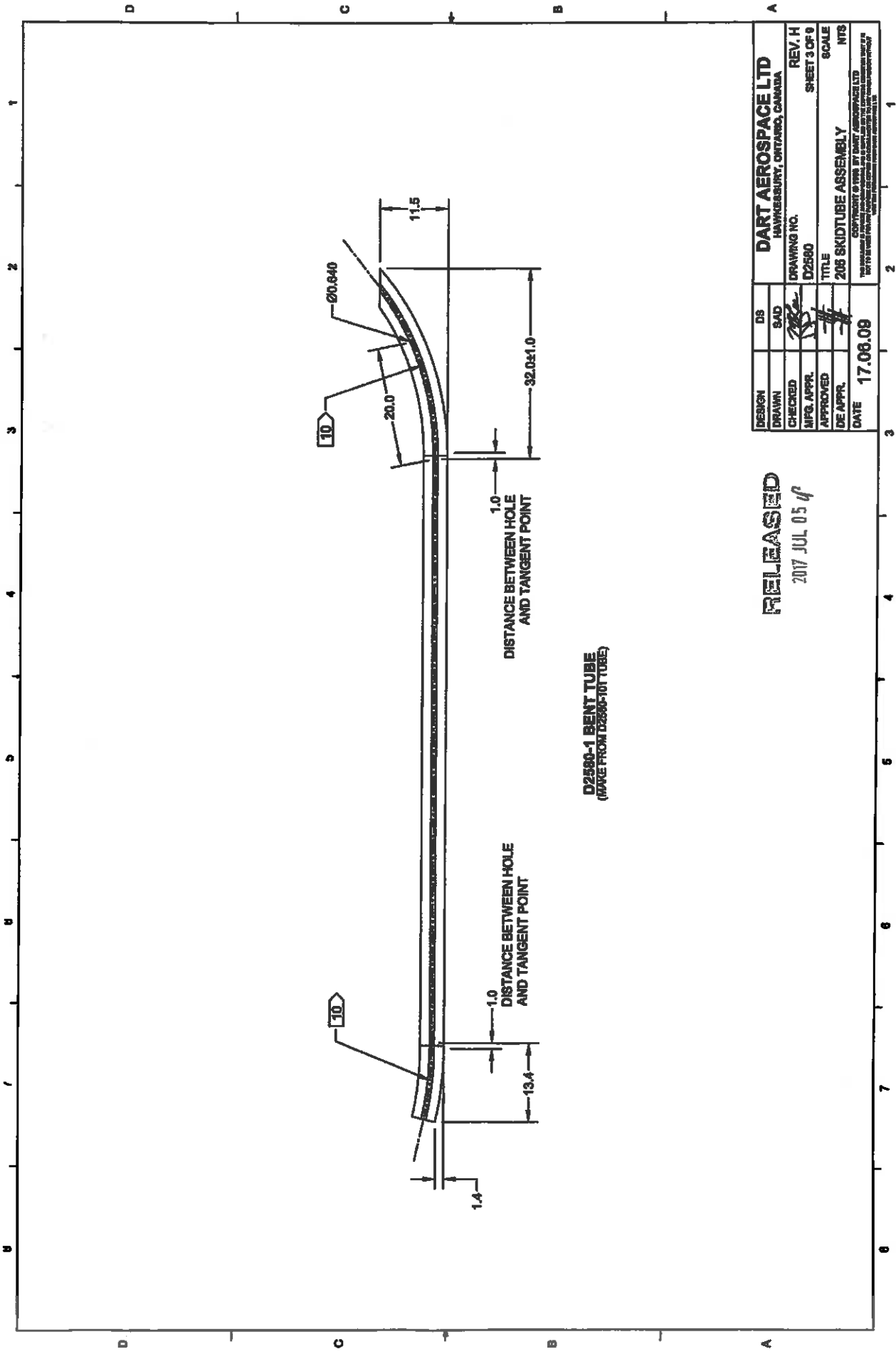
RELEASED

2017 JUL 05/1

201222 MJS

19-05-27

CONTROLLED COPY



**D2580-1 BENT TUBE**  
(WAVE FRONT D2580-101 TUBE)

**RELEASED**  
2017 JUL 05 4<sup>3</sup>

|                    |                    |                             |          |
|--------------------|--------------------|-----------------------------|----------|
| DESIGN             | DS                 | DATE                        | 17.06.09 |
| DRAWN              | SAD                |                             |          |
| CHECKED            | <i>[Signature]</i> |                             |          |
| MFG. APPR.         | <i>[Signature]</i> |                             |          |
| APPROVED           | <i>[Signature]</i> |                             |          |
| DE APPR.           | <i>[Signature]</i> |                             |          |
| TITLE              |                    | 206 SKIDTUBE ASSEMBLY       |          |
| SCALE              |                    | NTS                         |          |
| DRAWING NO.        |                    | D2580                       |          |
| SHEET 3 OF 9       |                    | REV. H                      |          |
| DART AEROSPACE LTD |                    | HAWKESBURY, ONTARIO, CANADA |          |

PROPERTY OF DART AEROSPACE LTD  
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD  
AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD

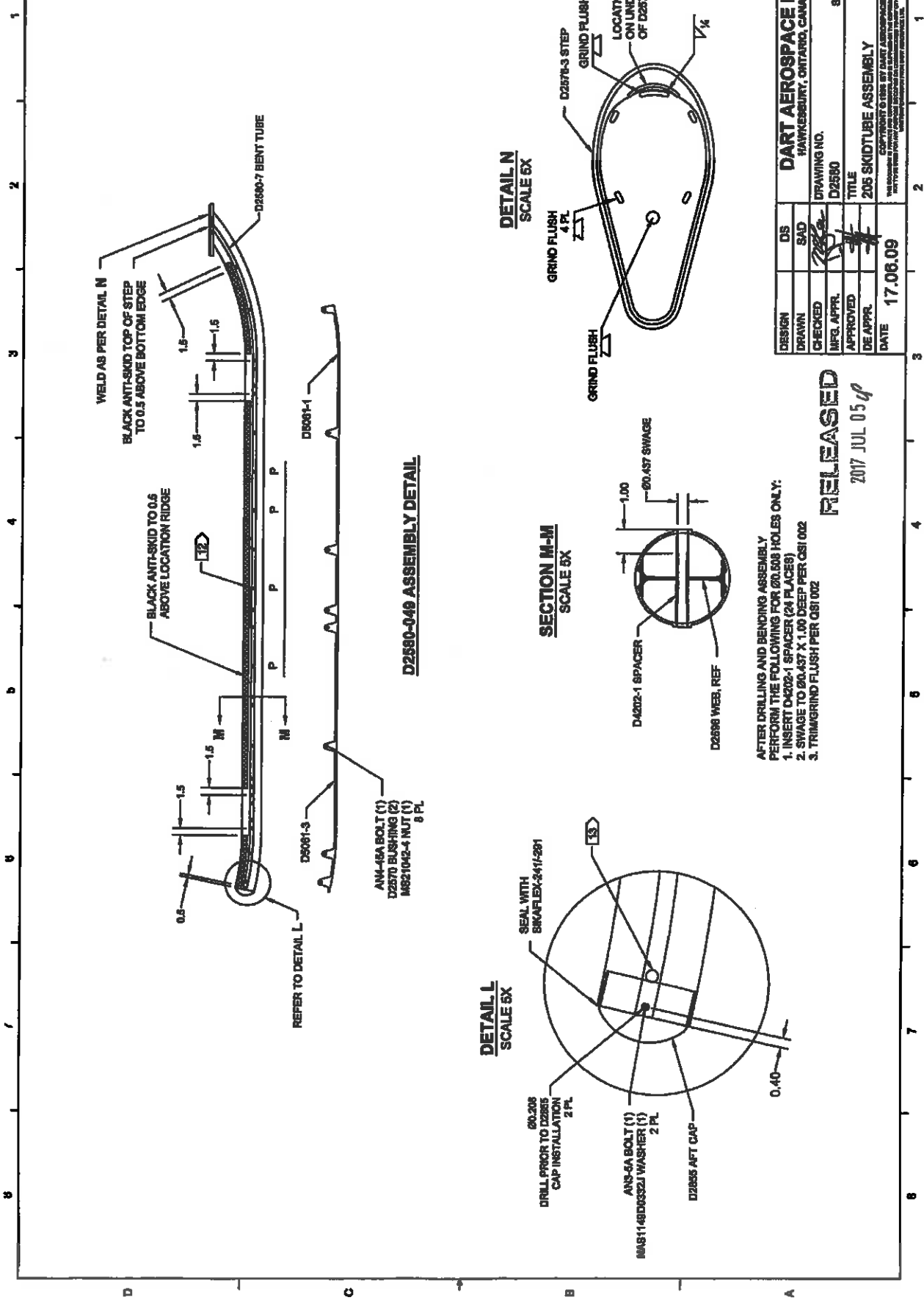




**PLEASE**

2017 JUL 05 *ap*

|          |                    |                                                                                                                                                                                                                                                      |                       |       |
|----------|--------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|-------|
| DESIGN   | DS                 | DART AEROSPACE LTD<br>HAMPSHIRE, ONTARIO, CANADA                                                                                                                                                                                                     |                       |       |
| CHECKED  | SAD                | DRAWING NO.                                                                                                                                                                                                                                          | REV. H                | SCALE |
| DESIGNED | <i>[Signature]</i> | D2580                                                                                                                                                                                                                                                | SHEET 5 OF 8          | NTS   |
| APPROVED | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                | 206 SKIDTUBE ASSEMBLY |       |
| DATE     | 17.06.09           | DOWNGRANT © 1988 BY DART AEROSPACE LTD<br>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. |                       |       |



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER Q31 002
3. TRIMGRIND FLUSH PER Q31 002

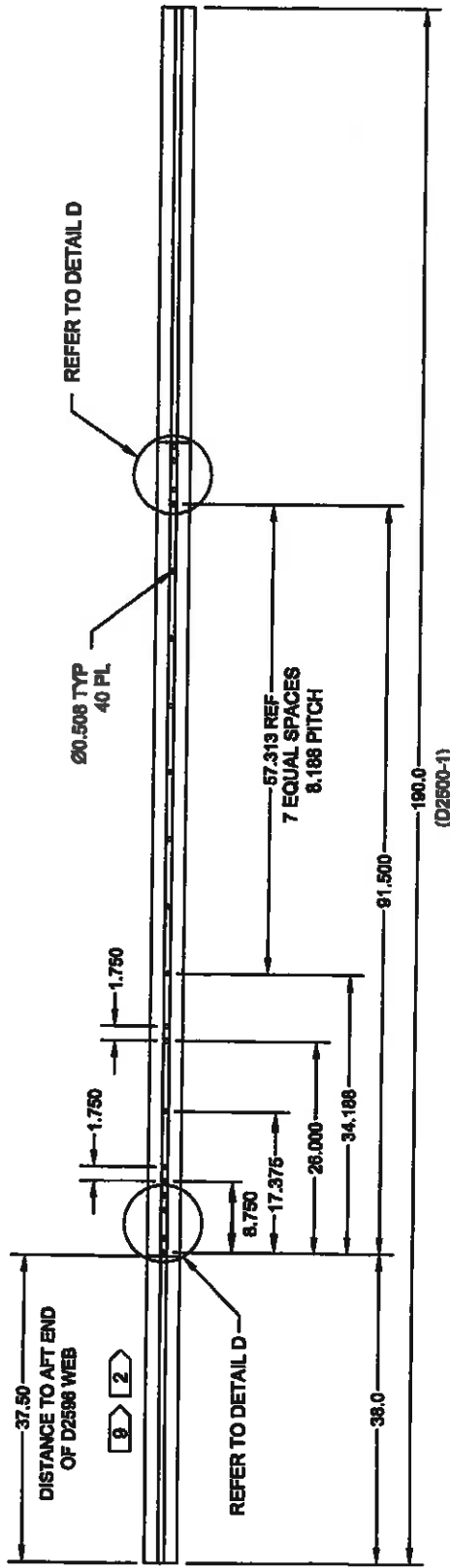
**RELEASED**  
2017 JUL 05 40

| DESIGN      | DS       | SAD | REV. H |
|-------------|----------|-----|--------|
| DRAWN       |          |     |        |
| CHECKED     |          |     |        |
| INFL. APPR. |          |     |        |
| APPROVED    |          |     |        |
| DE APPR.    |          |     |        |
| DATE        | 17.06.09 |     |        |

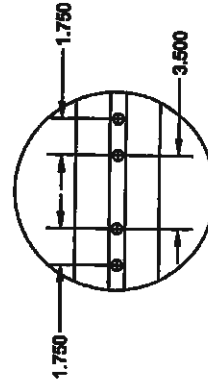
  

|                                                   |                      |                        |
|---------------------------------------------------|----------------------|------------------------|
| DART AEROSPACE LTD<br>HARRISBURG, ONTARIO, CANADA | DRAWING NO.<br>D2590 | REV. H<br>SHEET 7 OF 9 |
| TITLE<br>205 SKID TUBE ASSEMBLY                   |                      | SCALE<br>NTB           |

COPYRIGHT © 1996 BY DART AEROSPACE LTD  
ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.



# D2588-101 TUBE



RELEASED  
2017 JUL 05

|            |          |                             |
|------------|----------|-----------------------------|
| DESIGN     | D6       | DART AEROSPACE LTD          |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    |          | DRAWING NO.                 |
| MFG. APPR. |          | D2588                       |
| APPROVED   |          | TITLE                       |
| DE APPR.   |          | 205 SKIDTUBE ASSEMBLY       |
| DATE       | 17.06.09 | SCALE                       |
|            |          | NT8                         |

PROPERTY OF DART AEROSPACE LTD  
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.

Entered: \_\_\_\_\_ Date: \_\_\_\_\_

# WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only



|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |  |  |                                                   |  |              |  |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|---------------------------------------------------|--|--------------|--|
| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  | <b>DISPOSITION</b><br>Rework <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Scrap <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  | <b>DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Machining <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Large Fab <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Cross tube <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Small Fab <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Finishing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Engineering <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Water Jet <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Supplier <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Quality <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |  |  | Date: _____ Sequence #: _____ QTY Affected: _____ |  | MRB (QS1042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                     |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |  |  |                                                   |  |              |  |
| Root Cause<br>Operator <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Material <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Product Improvement <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Process Improvement <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Human Factors <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |  |                                                                                                                                                                                                                                                                                     |  | <b>FAULT CATEGORY</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  |  |  |                                                   |  |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  | Contamination <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>BOM/Route <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Incomplete/Unclear Instructions <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Fit/Function <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |  |  |                                                   |  |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  | Pressure/Forced <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Bending <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Crushing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Cracks <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Mislabeled <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |  |  |                                                   |  |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                     |  | Other/Details: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |  |  |                                                   |  |              |  |
| Completed By                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                     |  | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |  |  |                                                   |  |              |  |
| QC / QA Coordinator                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                     |  | Positioned Wrong <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Outside Tolerance <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Drawing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Finish <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/><br>Misread <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |  |  |                                                   |  |              |  |